

Work Order ID 53713

November 13, 2009 9:56:23 AM



Page 1

Item ID: D3552-11

Accept



Setup Start



Revision ID: D

Stop



Item Name: Door Prop

Start Date: 13/11/2009 Start Qty: 26.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 26.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RP*

Date: *09-11-13*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3552

Rev D

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *10753* ☐ Purchase Part Number: B8-240-575-150N ☐ Supplier:
LS Technologies ☐ Certificate of conformity is required

RP 09-11-13 *26*

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

RP 09-11-13 *26*

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Test for correct pressure

27 09/11/13

route
(426)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53713

November 13, 2009 9:56:23 AM



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Item ID: D3552-11

Accept



Setup Start



Revision ID: D

Stop



Item Name: Door Prop

Start Date: 13/11/2009 Start Qty: 26.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 26.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

09/11/23 (26)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/24 MF 09-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 9:56:29 AM

Page 1

Work Order ID: 53713



Parent Item: D3552-11RevD



Parent Item Name: Door Prop

Start Date: 13/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 26.00

Required Qty: 26.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
B8-240-575-150N		Purchased	No				Each	0.0000	26.0000			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

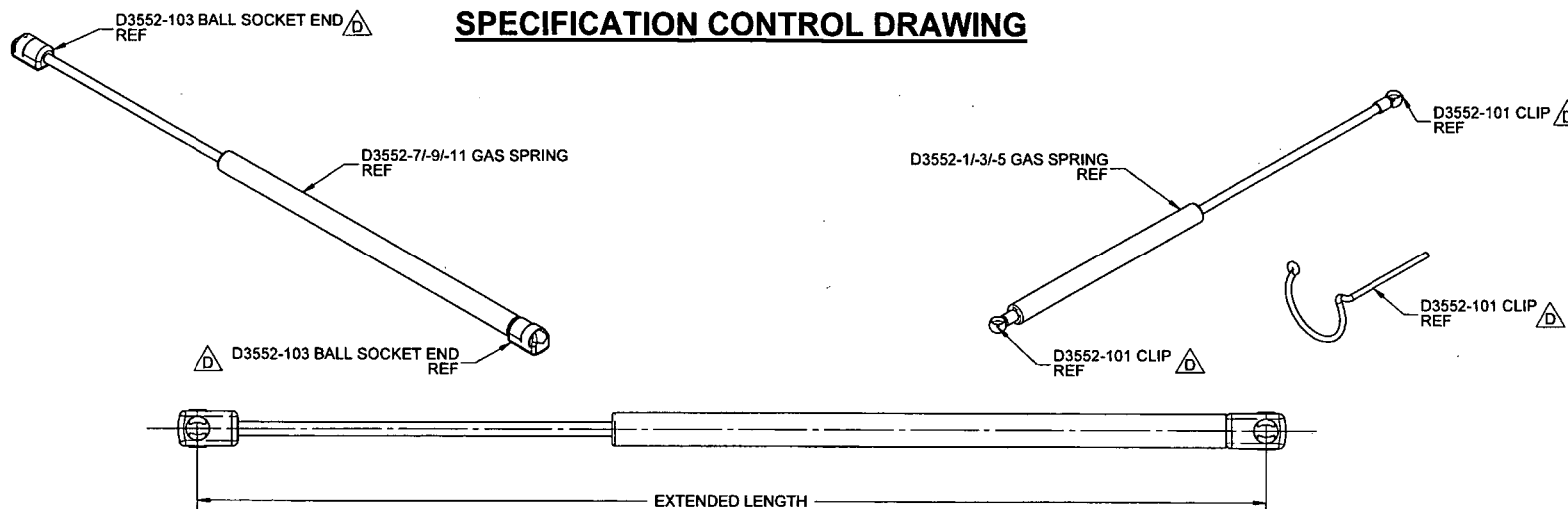
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



D3552-X GAS SPRING

DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER
D3552-1	GAS SPRING	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	GAS SPRING	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	GAS SPRING	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	GAS SPRING	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	GAS SPRING	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	GAS SPRING	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

RELEASED
07/15/13

NOTES:

- 1) IDENTIFICATION: IDENTIFY WITH DART P/N "D3552-X" AND B/N USING WHITE FINE POINT PERMANENT INK MARKER
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/3/5 GAS SPRINGS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/9/11 GAS SPRINGS

22-6
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53713
09/11/13

D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	07.06.01
B	ADD D3552-7/9; UPDATE DESC. D3552-1/3/5	06.10.24
A	NEW ISSUE	06.09.15
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.04.02	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3552

TITLE
GAS SPRING

REV. D
SHEET 1 OF 1
SCALE
NTS
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LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

P.O. No.	Date	Packing Slip #
10753	11/13/2009	5509

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Rep	Ship Date	Ship Via
Nolan	11/13/2009	Purolator

Qty	Description
26	B8-240-575-150N Gas Spring Shipping via PUROLATOR Collect - Tracking # 329152092709 Total GST Business Number: 875007718 <i>S</i> <i>01/10/23</i>



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

26 Units: B8-240-575-150N Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : 2009

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 10753

Invoice # 5509

8/14/23

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be "Nolan Fehr", written over a horizontal line.

Nolan Fehr
Manager



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO10753**

Purchase Order Date 13/11/2009

PO Print Date 13/11/2009

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

FAXED
13/11/09

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	306 683 5000	Requisition Nbr	
Vendor Fax	306 683 6403	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B8-240-575-150N		13/11/2009 Yes	✓ 26.00 Each	Purolator ground	\$41.3640	\$1,075.4

Special Inst: AS PER DRAWINGS D3552 REV D
B# 53713

PO Total: \$1,075.4

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 13/11/2009

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable